



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2583

Job Sheet 166348



Part No: D2583

Job Qty: 20 ea

Part Name: Latch Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Created By: Mario Poulin

Due Date: 10/31/17

Type: Stock

Description:

Note: DWG REV B IPP: C 00.11.01 Removed P/O for Powder Coat- in house process DM IPP: D

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2583 Latch Bracket	DWG REV B IPP: C 00.11.01 Removed P/O for Powder Coat- in house process DM IPP: D		0.000	
M5052H32S.040 5052-H32 .040 Sheet			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	20 Ea	10/30/17	0.00	0.00	Start up container	
160	Powdercoat	20 pcs	10/31/17	0.00	0.25	Powdercoat1	M/38014. DAS
170	QC	20 pcs	10/31/17	0.00	0.00	QC3	38
180	Packaging	20 pcs	10/31/17	0.00	0.00	Packaging3	9-89
190	QC21-SA	20 Ea	10/31/17	0.00	0.00	QC21	M/3 17-11-02

Part Op
Descriptions: 160 - START TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D2583 B166348		400 Ea (20 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2583 B166348	400	20	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Latch Bracket	3.380inches ± 0.010	3.390 3.370		
2	Latch Bracket	0.907inches ± 0.010	0.917 0.897		
3	Latch Bracket	1.725inches ± 0.010	1.735 1.715		
4	Latch Bracket	0.125inches ± 0.010	0.135 0.115		
5	Latch Bracket	0.980inches ± 0.010	0.990 0.970		

Status: Stock

Part: **D2583 B166348**

Created: 9/30/17 11:48 AM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: **S000073**

Printed By: Goldston, Justin 10/2/17 10:44 AM

Work Order Summary

Thursday, September 28, 2017 8:02:38 AM

Page 1 of 2

Criteria : Work Order ID: 166348 Item ID: D2583 Product Family SMALL FAB
Work Order Start Dates 9/18/2017 to 9/18/2017 11:59:59 PM Work Order Required Dates 9/22/2017 to 9/22/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID	166348	Required Qty	20.0000	Status Code	Released
Item ID	D2583	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Latch Bracket				
Current Acct Value	\$10.983				

Start Date	9/18/2017	Required Date	9/22/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$6.355	\$0.000	\$0.317	\$0.317	100.00%
Labor	\$49.464	\$0.000	\$3.111	\$3.111	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$122.180	\$0.000	\$7.554	\$7.554	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$177.999	\$0.000	\$10.983	\$10.983	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
M5052H32S.040					
5052-H32 .040 Sheet	2.4611		9/22/2017	3.0000	\$6.355
Total Matl Amts:					\$6.355

Work Center Brake NC

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUC01												
9/27/2017												
130			0.17	0.17	0.42	0.42	1.00	\$3.584	\$8.959	\$25.460	\$0.000	\$38.003
Total:			0.17	0.17	0.42	0.42	1.00	\$3.584	\$8.959	\$25.460	\$0.000	\$38.003

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LECO02												
9/27/2017												
150			0.00	0.00	0.53	0.53	1.00	\$0.000	\$11.546	\$28.821	\$0.000	\$40.367
Total:			0.00	0.00	0.53	0.53	1.00	\$0.000	\$11.546	\$28.821	\$0.000	\$40.367

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
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CARR02

9/22/2017

100			0.00	0.00	1.23	1.23	1.00	\$0.000	\$25.375	\$67.900	\$0.000	\$93.275
	Total:		0.00	0.00	1.23	1.23	1.00	\$0.000	\$25.375	\$67.900	\$0.000	\$93.275

Work Order ID 166348

Monday, September 18, 2017 8:52:01 AM

166348

Page 1

Item ID: D2583 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Latch Bracket
Start Date: 9/18/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 9/22/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: DAS Date: SEP 18 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2583	Rev B								
100	FLOW WATER JET	0.00							<u>DAS</u> <u>40</u> <u>9-89</u>
100									
Waterjet	Memo	0.45							
FLOW CNC Waterjet	1-Cut as per Dwg D2583 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							<u>DAS</u> <u>40</u> <u>9-89</u>
110									
QC	Memo	0.20							
Quality Control									
120	QC8- Inspect parts - second check	0.00							<u>DAS</u> <u>38</u> <u>9-89</u>
120									
QC	Memo	0.40							
Quality Control									<u>20</u> <u>SEP 25 2017</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo DeburrForm on CNC Brake as per Dwg D2583	0.23 0.52			DAS 30 9-89	20			SEP 26 2017
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.40				20			DAS 38 9-89 SEP 27 2017
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.48				(20)	0	2017-09-27	JSL

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 138014.</i> Memo START TIME: <i>1:25</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>1:25</i>	0.00 0.50				<i>20</i>	<i>0</i>	<i>17.10.18</i>	<i>33</i> 9-18-17
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.20				<i>20</i>			<i>38</i> 9-18-17 OCT 19 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.20							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, September 18, 2017 8:52:04 AM

Work Order ID: 166348

166348

Parent Item: D2583

D2583

Parent Item Name: Latch Bracket

Start Date: 9/18/2017

Required Date: 9/22/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	75.6687	0.1169	2.461053			DAS 40 9-89
M5052H32S 040									**			17/09/22	
5052-H32 .040 Sheet													

Location	Loc Qty	Loc Code
MAT	7.7	
m135512	7.7	
MAT022	11.4	
m134774	11.4	
MAT023	56.568684	
m1342217	1.313684	
m134617	2.1	
m136102	2.8	
m136897	9.355	1,5
m137599	4	
m137844	37	1,5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

DART AEROSPACE LTD	Work Order:	166348
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	17/09/22	Date:	SEP 25 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

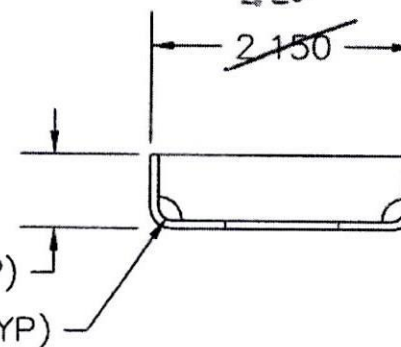
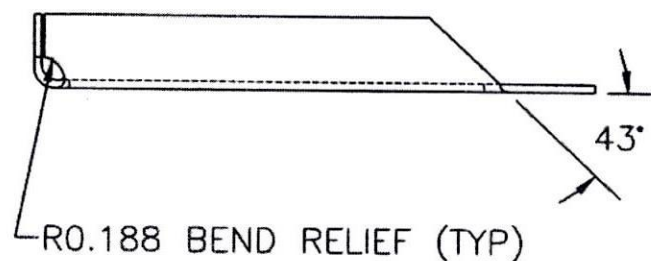
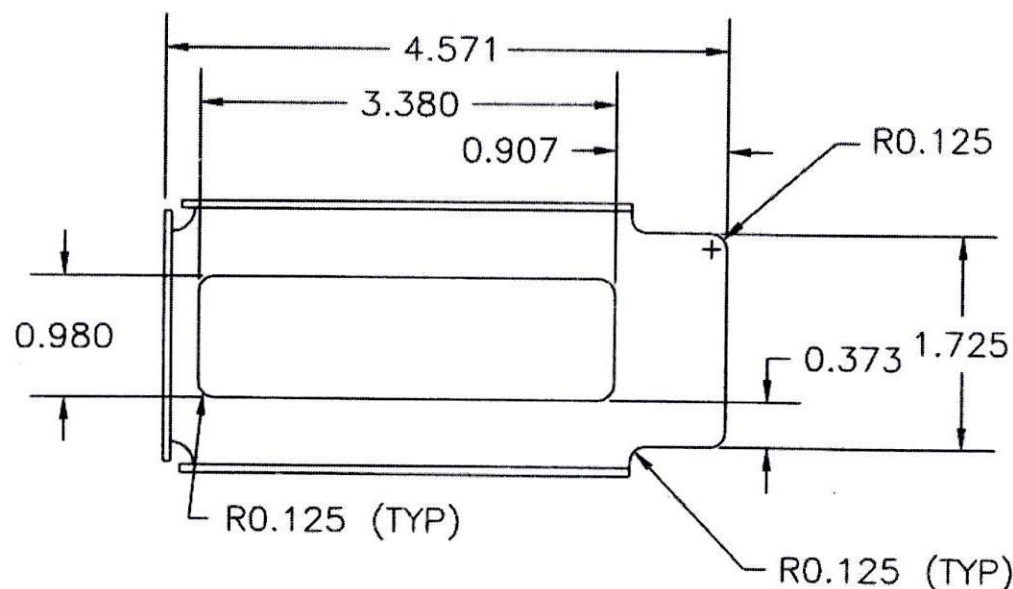
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : ☐							

DART



RELEASED
KE 99.02.25

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166348 MJS
1709.18 KE 99.02.26
220



DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B SHEET 1 OF 1
		SCALE	2:3	
A	96.07.10	NEW ISSUE		
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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